

Date: Wednesday, 7/4/2007 3:32:43 PM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER AND LOWER PLATE		
Job Number	: 33296				
Estimate Number	: 12837				
P.O. Number	: N/A	Part Number	: D35241		
This Issue	: 7/4/2007	S.O. No.	: N/A		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: N/A	Drawing Revision	: N/A		
Previous Run	: 32193	Material	: N/A		
Written By	<u>JLM 07-07-12</u>				
Checked & Approved By					
Comment	Est Rev:A New Issue 07-04-18 EC Est Rev:B Now CNC Machined 07-06-28 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0375X0250 3.00	6061-T6 Bar 3/8 x 25.0 3"
Comment: Qty.: 0.2365 f(s)/Unit Total : 0.4729 f(s) 6061-T6 Bar .375" X 25.0 Batch: M18237		CERTIFICATE OF CONFORMITY REQUIRED
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut Blanks 2.750" Long		J.F. 07/07/11
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		J.F. 07/07/11
1- Mill as per Folio FA699 Rev: A & Dwg D3524 Rev: A		
2-Deburr per dwg D3443		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		J.F. 07/07/11
5.0	QC8	SECOND CHECK
 <i>CB</i> <i>07.07.11</i> ENGINEERING APPROVAL		
Comment: SECOND CHECK		J.F. 07/07/11

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 33296

Part Number: D35241

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

FOR ENGINEERING USE ONLY

Location: _____

RE 07.07.19

10.0 QC21

FINAL INSPECTION/W/O RELEASE



07.07.19 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

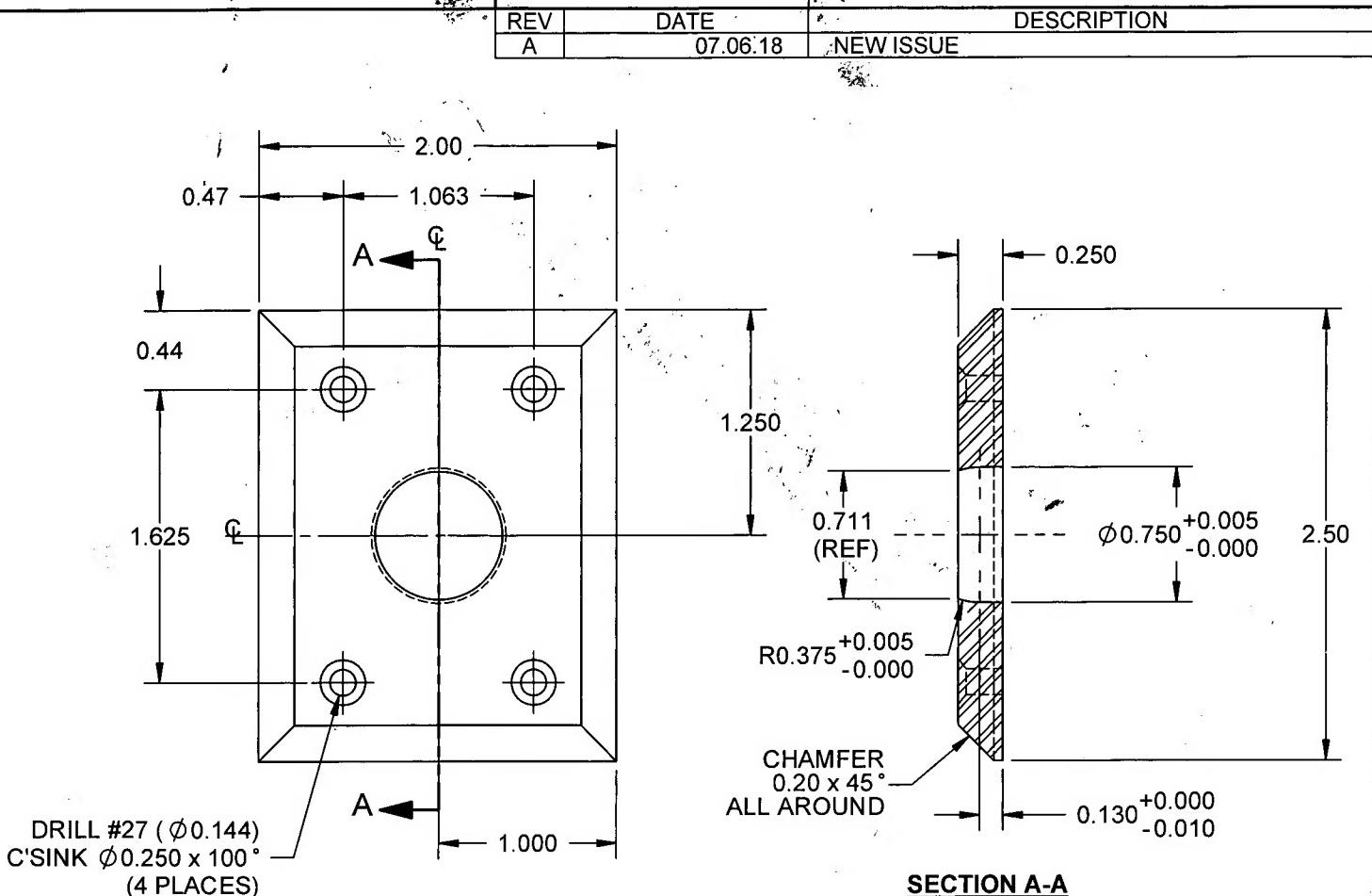
Job Completion



CD 07/07/18

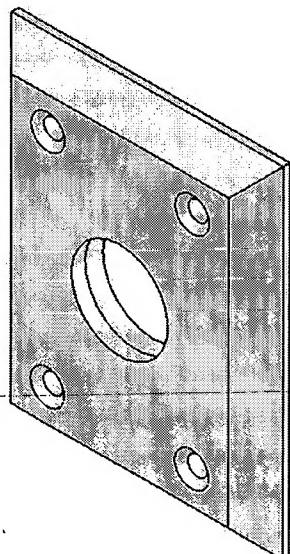
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
07-07-10 CB

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED	DRAWING NO. D3524	REV. A	SHEET 1 OF 3
DATE 07.06.18		TITLE UPPER AND LOWER PLATE	SCALE	1:1
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE		



SECTION A-A

D3524-1 LOWER PLATE

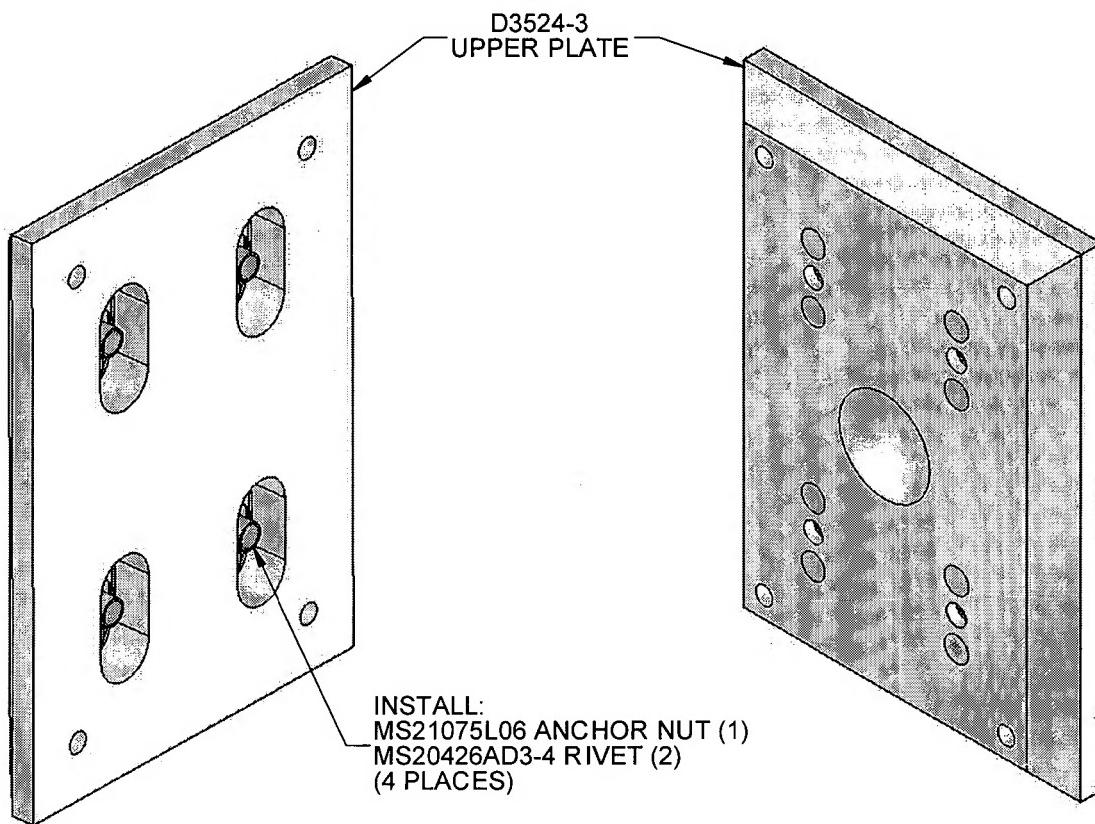


NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT \varnothing

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
07.07.10 CB

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.06.18		TITLE UPPER AND LOWER PLATE	SCALE 1:1



D3524-041 UPPER PLATE ASSEMBLY

PARTS LIST:

QTY	P\N	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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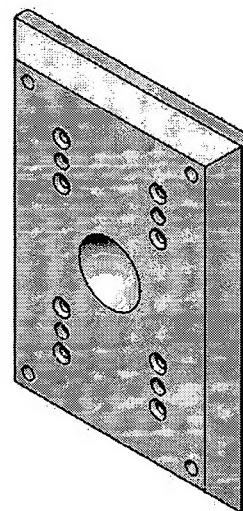
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PROTOTYPE
SE RETURN ALL ISSUES

PLEASE RETURN ALL ISSUED
DATA TO THIS LIBRARY

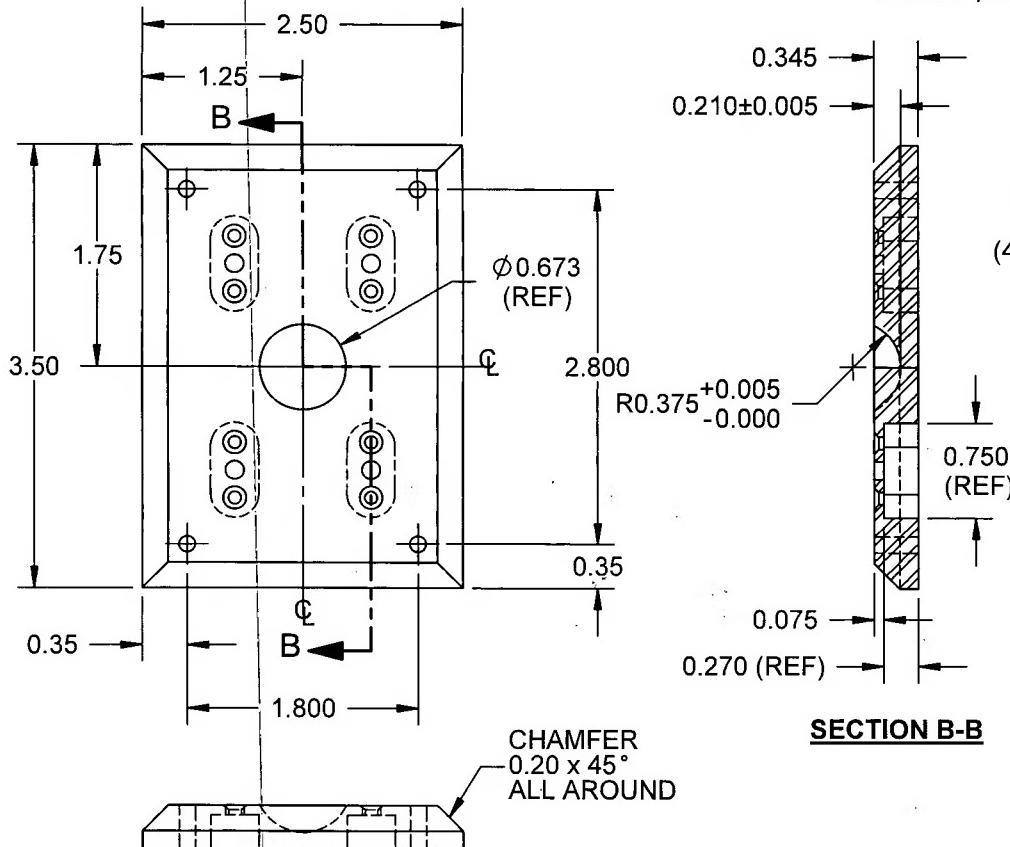
07.07.10 C B

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DESIGN	DRAWN BY
C B	C B
CHECKED	APPROVED
L E	D3524
DATE	TITLE
07.06.18	UPPER AND LOWER PLATE
	SCALE
	2:3
	SHEET 3 OF 3
	REV. A



D3524-3 UPPER PLATE

SECTION B-B



NOTES

- NOTES:**

 - 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
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DART AEROSPACE LTD	Work Order:	33296
Description: Lower Plate	Part Number:	03524-1
Inspection Dwg: 3524 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SF	Audited by:	SD	Prototype Approval:	CB
Date:	07/07/10	Date:	07.07.10	Date:	07.07.11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 05/08/09
Supplier: Copper & Brass

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr.

Batch No: m18237
Dart P/O: 2008415

Release Note Attached: Yes No N/A
Waybill Attached: Yes No
Shipment Complete: Yes No
Q.C. Inspection

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>m60061T6B0.375X01.000</u>		<u>48</u>	<u>0</u>	<u>0</u>	<u>48</u>	

TSR No. _____

Initials of receiver (if shipment OK) CDY

Production/Admin:

Date 05/08/10
Received/Costing 2008415

Initial A

H:\ISO9000\Forms\Purchase\RECREPORT rev B

Accounting:

Date _____
AP/MR _____
Initial _____

SPECIAL INSTRUCTIONS

"Shipping, do not place any packages or goods on top of our material."

FULL	SCRAP	FILED BY		PACKED BY		QA AUDIT	
CUSTOMER RECEIVING HO JRS		MAX SKID WEIGHT		LOADING INSTRUCTIONS		MAXIMUM BUNDLE WEIGHT	
BOXES	BARS	CASES	CUSH/P	PKGS	SKIDS	BDLS	TUBES
INSPECTION RECORD							

TEST RESULTS -----

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds or call 248-233-5682. We hereby certify that the material above complies with the following specifications:

ASTM-B221

AMS-QQ-A-200/8

TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
181934 00 31.00 LB ALCOA E 0C74914 629545-001

PCS ! TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
! !

PCS

SHIP DATE 08/09/05	GROSS WEIGHT 50	QUOTE 30-143875-2	OF 4	PACKING LIST																														
SHP	WORK ORDER **	ORDER DATE 08/04/05 ORD	TEST RESULTS																															
AEROSPACE			DELIVERY DATE 08/09/05	SHIP BRANCH 30-TOR																														
ART AEROSPACE 1270 ABERDEEN ST HAWKESBURY ON CANADA	SHIP TO 01	SELL BRANCH 30-TOR	WORK ORDER UV4618																															
6905 KENDRICK GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y																																		
Copper and Brass Sales Canada A ThyssenKrupp Materials NA company																																		
																																		
ThyssenKrupp																																		
DATE:																																		
<table border="1"> <tr> <td colspan="2">CUSTOMER P.O. NUMBER 2008415</td> <td>TERRITORY 01</td> <td>ENTRY ID 30MAC</td> <td>CUSTOMER SIGNATURE:</td> </tr> <tr> <td colspan="2">BUYER LINDA LACELLE</td> <td colspan="3">INSIDE SALES MARIO A. CARREIRO</td> </tr> <tr> <td colspan="2">BUYER TELEPHONE (613) 632-9577</td> <td colspan="3">INSIDE SALES TELEPHONE (905) 696-8100 223</td> </tr> <tr> <td colspan="2">SHIP VIA INTERNAL</td> <td colspan="3">SHIPPING STATUS COMPLETE X PARTIAL CANCEL</td> </tr> <tr> <td colspan="2">TO CUSTOMER COMMON/FRT-</td> <td>FOB DEST</td> <td colspan="2">PACKED WITH OTHER GOODS</td> </tr> <tr> <td colspan="2">BILL OF LADING</td> <td>FREIGHT STATUS PPD</td> <td colspan="2">FINISHED GOODS LOCATION</td> </tr> </table>					CUSTOMER P.O. NUMBER 2008415		TERRITORY 01	ENTRY ID 30MAC	CUSTOMER SIGNATURE:	BUYER LINDA LACELLE		INSIDE SALES MARIO A. CARREIRO			BUYER TELEPHONE (613) 632-9577		INSIDE SALES TELEPHONE (905) 696-8100 223			SHIP VIA INTERNAL		SHIPPING STATUS COMPLETE X PARTIAL CANCEL			TO CUSTOMER COMMON/FRT-		FOB DEST	PACKED WITH OTHER GOODS		BILL OF LADING		FREIGHT STATUS PPD	FINISHED GOODS LOCATION	
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PART DESCRIPTION: 019914-1																																		
RECT 6061-T6511 EXTR ALUMINUM BAR, 3/8 (+/- .008) X 3 (+/- .024) X 12 FT ML NO PROCESSING - 144" ML, Test Results Attn to: QA Department.																																		
<i>ASME B22.1</i>																																		
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PULL		SCRAP	FILLED BY GM	PACKED BY																														
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BOXES	BARS	CASES	CUSHP	PKGS	SKIDS	BOLTS	TUBES	CTNS	FLAT 1	COILS																								
INSPECTION RECORD																																		

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PCS ! TAG NO QUANTITY UOM VENDOR VEND PO HEAT/LOT

PCS

INSPECTION REPORT

MADE IN BRAZIL

N.: 120085402-001

N.: AS4043DI

STANDARD: 1

TO: COPPER AND BRASS SALES (CA)
 6905 KENDERRY GATE UNIT 4
 MISSISSAUGA - ONTARIO
 CANADA L5T 2Y8

We hereby certify that the material covered by this report has been inspected in accordance with, has been found to meet, the applicable requirements described herein, including any specifications forming accordance with, and part of the description that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per WILKER L. PEREIRA

QUALITY CONTROL

Item : 07

BC132

Alloy : 6061

Temper: T6511

Item Description

ALUM FLAT BAR

.375 3.000 .000 X 12 FT

CHEMICAL COMPOSITION

CAST	Si	Fe	Cu	Mn	Mg	Ti	Cr	Zn	B	Pb	Bi
19686	0.6300	0.2050	0.2670	0.0310	0.8900	0.0160	0.0440	0.0060	0.0086	0.0004	0.0032

EXTRUDED SHAPES

N. OF TESTS: 3

UTS (KSI)	Min	Max	TYS (KSI)	Min	Max	EL (%)	Min	Max
41.79		43.82	37.74		40.17	15.76		16.24

UTS (KSI) 43.82 43.26 41.79

TYS (KSI) 40.17 38.12 37.74

EL (%) 16.24 16 15.76

OBSERVATIONS

ITEM IDENTIFICATION: 629545-001

ENCOMENDA ALCOA: 14881607 (BC132)

P.O. CONSIG.: C74914